

Work Order ID 69031

Wednesday, April 27, 2011 10:59:03 AM



Page 1

Item ID: D2939-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH In, 206

Start Date: 4/27/2011 Start Qty: 9.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 9.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

R

Date: 4/27/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2939

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

SL 11/06/01

⑨

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL 11/06/01

9

P

120

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

SL 11/06/01

9

P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69031

Wednesday, April 27, 2011 10:59:03 AM



Page 2

Item ID: D2939-2	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Saddle RH In, 206					
Start Date: 4/27/2011	Start Qty: 9.00		Cust Item ID:		
Required Date: 5/3/2011	Req'd Qty: 9.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				9	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				9	0		M-11/06/02
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00				9	0		M-11/06/03

Memo
 START TIME: 8:20
 FINISH TIME: 8:50
 OVEN TEMPERATURE: 320°F

M116964

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69031

Wednesday, April 27, 2011 10:59:03 AM

Page 3

Item ID: D2939-2

Accept

Revision ID:

Item Name: Saddle RH In, 206

Start Date: 4/27/2011 Start Qty: 9.00

Required Date: 5/3/2011 Req'd Qty: 9.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

9 PR 11-6-3.

170



Packaging

Packaging

Identify as per dwg & Stock Location: 429

0.00

Memo

0.00

Pw/4/3 (G)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 11/06/03

MF 11-06-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, April 27, 2011 10:59:11 AM

Work Order ID: 69031



Parent Item: D2939-2



Parent Item Name: Saddle RH In, 206

Start Date: 4/27/2011

Required Date: 5/3/2011

Start Qty: 9.00

Required Qty: 9.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001

Manufactured

No

100

Each

51.0000

1

9



Saddle Billet

SL 11/06/01

Location

Loc Qty

Loc Code

MAT040

51

64777

20

66965

10

68170

21

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

DART AEROSPACE LTD				Work Order: 69031	
Description: 206 Saddle, Inboard, Right side				Part Number: D2939-2	
Inspection Dwg: D2939 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.122	.122	.122	.121	.121
B	0.100	0.140		.122	.122	.122	.121	.121
C	0.100	0.140		.117	.117	.117	.117	.117
D	0.210	0.230		.220	.221	.221	.221	.221
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.514	.514	.514	.514	.514
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.257	.257	.257	.257	.257
L	0.312	0.317		.313	.313	.313	.313	.313
M	0.235	0.240		.238	.238	.237	.238	.238
N	0.100	0.140		.121	.121	.121	.121	.121
O	0.540	0.560		.550	.549	.550	.550	.550
P	0.490	0.510		.501	.501	.501	.500	.501
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		.250	.250	.249	.249	.248
T	0.100	0.180		.140	.140	.140	.140	.140
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.250	1.270		1.262	1.263	1.264	1.264	1.264
Y	1.565	1.585		1.572	1.578	1.574	1.574	1.574
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: SL	Date: 11/06/01
Audited by: [Signature]	Date: 11/06/01
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 69031
Description: 206 Saddle, Inboard, Right side		Part Number: D2939-2
Inspection Dwg: D2939	Rev: C	Page 1 of 1

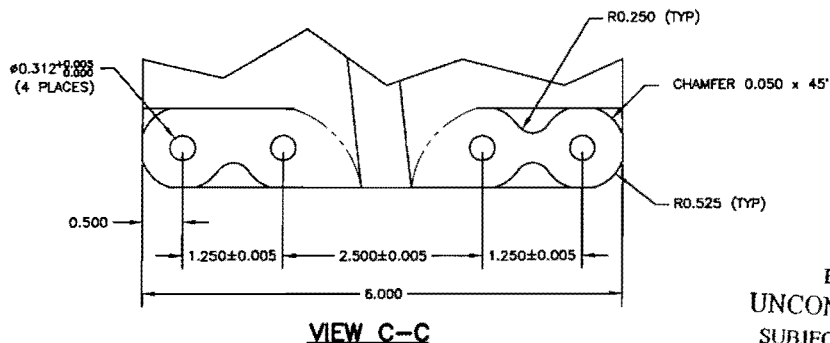
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	5
A	0.100	0.140		.121	.121	.121	.121	
B	0.100	0.140		.121	.121	.121	.121	
C	0.100	0.140		.117	.116	.117	.117	
D	0.210	0.230		.220	.221	.221	.220	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.514	.514	.514	.514	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.257	.257	.257	.257	
L	0.312	0.317		.313	.313	.313	.313	
M	0.235	0.240		.238	.238	.238	.238	
N	0.100	0.140		.121	.121	.122	.121	
O	0.540	0.560		.550	.550	.550	.550	
P	0.490	0.510		.502	.502	.501	.501	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.720	2.760		2.740	2.740	2.740	2.740	
S	0.240	0.270		.248	.248	.247	.249	
T	0.100	0.180		.140	.140	.140	.140	
U	1.625	1.635		1.630	1.630	1.625	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.316	.316	.316	.316	
X	1.250	1.270		1.265	1.265	1.265	1.267	
Y	1.565	1.585		1.580	1.580	1.580	1.579	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: JI	Date: 11/06/01
Audited by: CMX	Date: 11/06/01
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
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D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

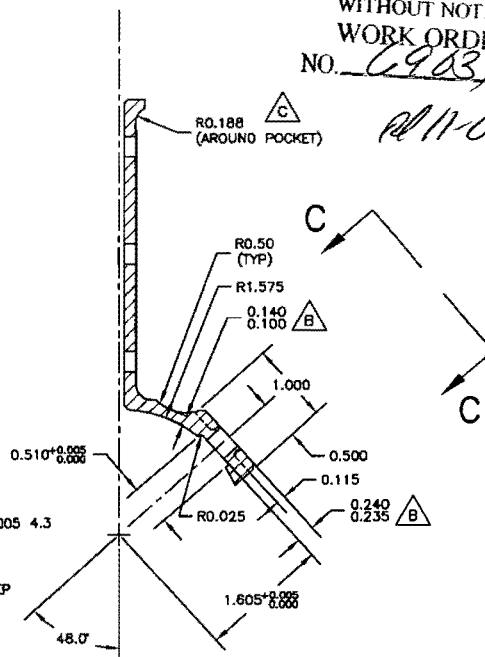


VIEW C-C

D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

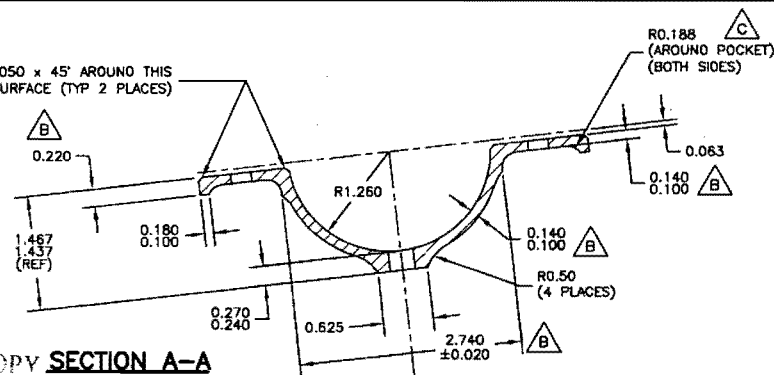
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

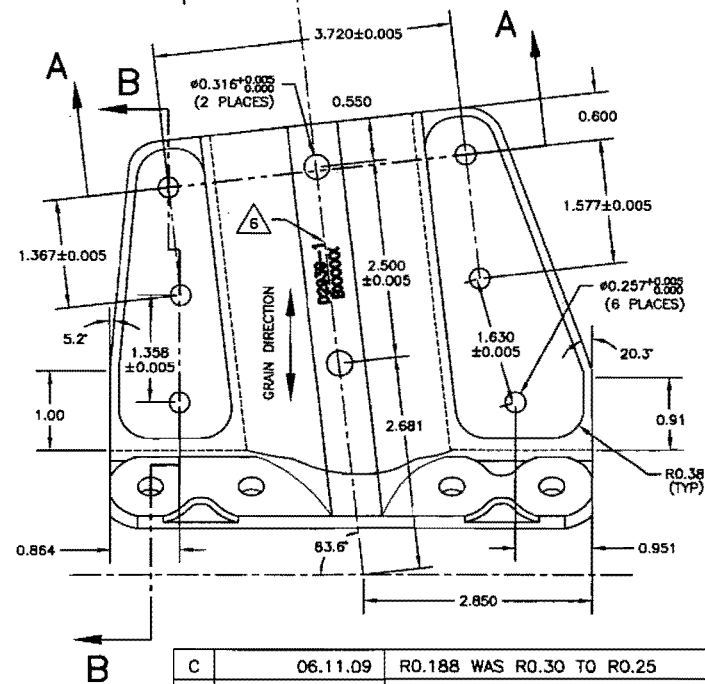


SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2939
DATE	06.11.09	TITLE SADDLE INSIDE

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REV. C
 SHEET 1 OF 1
 SCALE 2:3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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